

Work Order ID 129258

January-30-15 11:10:21 AM

Blue
129258

Page 1

Item ID: D3394-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 1/30/15 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: *V* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3394 DEO	Rev B

102 0.00

102

Purchasing Memo 0.00
 Purchasing ISSUE PO TO METEC 27301
 MACHINE PER DRWG D3394 REV.B

CX 15/02/02 (24)

103 Receive & Inspect for Damage & Mat'l Certs 0.00

103

Packaging Memo 0.00
 Packaging

24x 8015-02-17

104 *Q26* ~~QC14~~ Inspect Spray Paint 0.00

104

QC Memo 0.00
 Quality Control

(24)

DAS
38
9-89

FEB 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

January-30-15 11:10:21 AM

Item ID: D3394-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug

Stop *NS2*

Start Date: 1/30/15 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 2/13/15 **Req'd Qty:** 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

105

Chemical Conversion Coat per QSI005 4.1

0.00

105

HandFinish

Memo

0.00

Hand Finishing

24 0 Jm15-3-11

106

QC7-Inspect Chemical Conversion Coat

0.00

106

QC

Memo

0.00

Quality Control

24 DAS
41
9-89

15-4-20

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Large Fab ☐	Composite ☐	Supplier ☐																

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 129258

January-30-15 11:10:21 AM

129258

Page 3

Item ID: D3394-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 1/30/15

Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/13/15

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

107

0.00

107

SprayPaint

Spray Painting

Memo

PRIME B 131846DELFLEET BLUE B 128955DELFLEET CLEAR B 129271

PRIME:

Start Time: 1230Finish Time: 100

PAINT:

Start Time: 200Finish Time: 245

0.00

24

DAS

41

9-89

15-4-20

108

QC14- Inspect Spray Paint

0.00

108

QC

Quality Control

Memo

0.00

24

DAS

38

9-89

APR 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 129258

129258

Page 4

January-30-15 11:10:21 AM

Item ID: D3394-3 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Lug Stop *NS2*
 Start Date: 1/30/15 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Identify as per dwg & Stock Location. <i>st S28</i>	0.00				<i>24</i>	<i>DAS 27 9.00</i>		
110									
Packaging	Memo	0.00							
Packaging	RE-STOCK AS D3394-3								
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

APR 22 2015

MLJ 15-04-023

AS.4-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

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Picklist Print

January-30-15 11:15:54 AM

Page 1

Work Order ID: 129258

129258

Parent Item: D3394-3

D3394-3

Parent Item Name: Lug

Start Date: 1/30/15

Required Date: 2/13/15

Start Qty: 24.00

Required Qty: 24.00

Comments: New Issue 11/01/10 LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3394-3P *D3394-3P* Lug		Purchased	No				Each	0.0000		24			

**

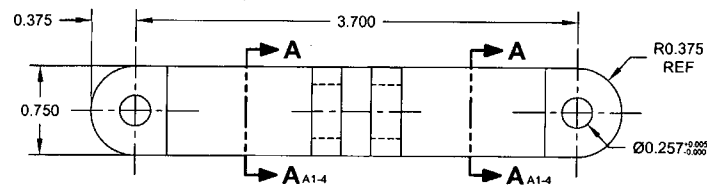
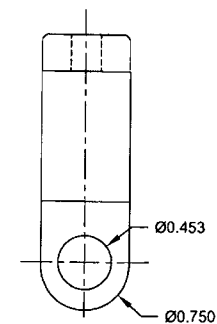
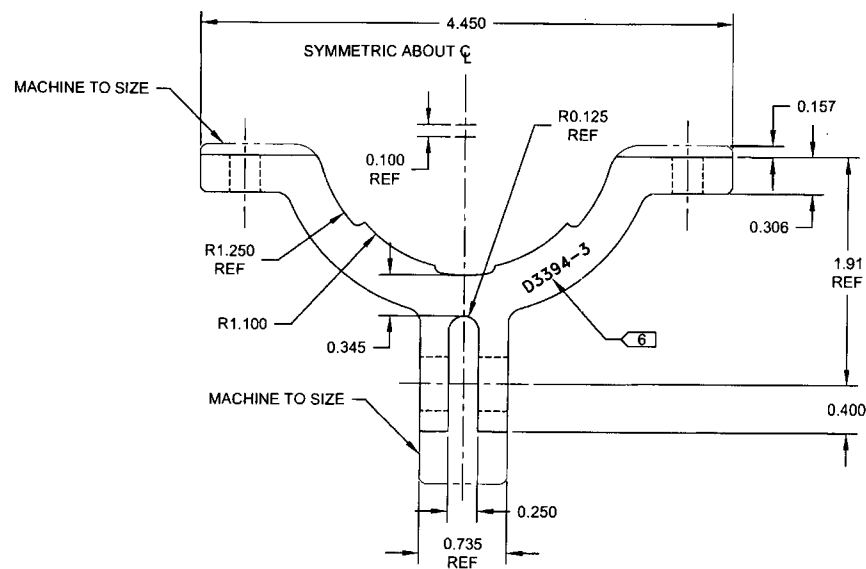
24x SP15-02-17

D2423 ✓

B115529

07 = 1.68 ft
X

CL15/02/03



D3394-3 LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

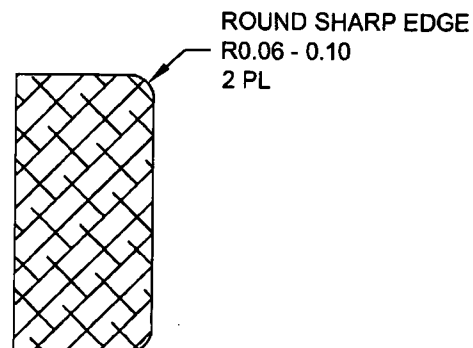
RELEASED
09/05/25

DESIGN		PH	DART AEROSPACE LTD	
DRAWN		A.S.	HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D3394	SHEET 3 OF 4
APPROVED			TITLE	SCALE
DE APPR.			LUG	NTS
DATE		09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09/11/04		DATE 09/11/04		

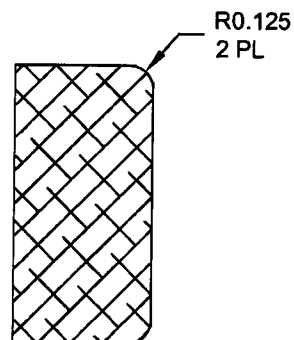
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

RELEASED
2009-11-25
WJD

REASON: DRAFTING ERROR

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27301

Purchase Order Date 2/2/2015

PO Print Date 2/2/2015

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

1	D2731-7P	Lug	2/9/2015		24.00	\$13.00	\$312.00
			Yes		Each		
			2/9/2015				

AS PER DWG D2731 REV. C
B129255

NOTE: NO ALODINE AND NO PAINT REQUIRED

Line Total: \$312.00

2	D3394-3P	Lug	2/9/2015		24.00	\$14.00	\$336.00
			Yes		Each		
			2/9/2015				

AS PER DWG D3394 REV. B
B129258

NOTE: NO ALODINE AND NO PAINT REQUIRED

Line Total: \$336.00

Note:

2/2/2015



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 20297
Date: Feb 10, 2015
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 27301	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Feb 10, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG as per drawing D2731 Rev.C No Alodine and No Paint required	Each	24	24	
D3394-3 Lug as per drawing D3394 Rev.B No Alodine and No Paint required	Each	24 ✓	24 ✓	
SP15-02-17				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



METAL TECHNOLOGY INC.

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

24	D2731-7	Lug	27301
24	<u>D3394-3</u>	Lug	27301

MATERIAL: supplied by DART B115529

SP15-02-17

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, February 10 2015